

5/13

DART AEROSPACE LTD	Work Order:	22514 B
Description: Bracket Assembly	Part Number:	D2803-042
Dwg: D2803 Rev. B	Qty:	15 20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	PA	05.02.23	20																				
2	GA	Press D2805-2 into arm as per Dwg D2803 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2803-2</td><td>Bracket B 22524A</td><td>B 22524B</td></tr><tr><td>1</td><td>D2805-2</td><td>Stop</td><td>B 22521</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B 22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2803-2	Bracket B 22524A	B 22524B	1	D2805-2	Stop	B 22521	1	D2809	Bushing	B 22529	SB	25/03/28	20				
Qty	Part Number	Description	Batch																						
1	D2803-2	Bracket B 22524A	B 22524B																						
1	D2805-2	Stop	B 22521																						
1	D2809	Bushing	B 22529																						
3	QC5	Inspect work to Step 2	J	05.03.28	20																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	MM	05.03.29	20																				
5	QC3	Inspect Powder Coat	SB	05/03/31	15																				
6	GA	Press D2809 into arm as per Dwg D2803	SB	05/03/31	15																				
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt M17185</td><td>M17046</td></tr><tr><td>2</td><td>MS21042L3</td><td>Nut (or -3) M17187</td><td>M16944</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer M17187</td><td>M16944</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M16863</td></tr></table> MS21043-3 05.03.29	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt M17185	M17046	2	MS21042L3	Nut (or -3) M17187	M16944	4	NAS1515H3	Washer M17187	M16944	A/R	LPS-3	Corrosion Spray	M16863	SB	05/03/31	15
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt M17185	M17046																						
2	MS21042L3	Nut (or -3) M17187	M16944																						
4	NAS1515H3	Washer M17187	M16944																						
A/R	LPS-3	Corrosion Spray	M16863																						
8	GA	Assemble as per Dwg D2803.	SB	05/03/31	15																				
9	QC5	Inspect work to Step 8	PO	05.03.31	15																				
10	ST	Identify and Stock	KD	05/03/31	15																				
11	AC	Cost / part: 81.07	S4C	05.04.01	15																				
12	DC	Close W/O 81.07 Inspect Level 21	KJ	05.04.05	15																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	

RELEASED
05/05/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

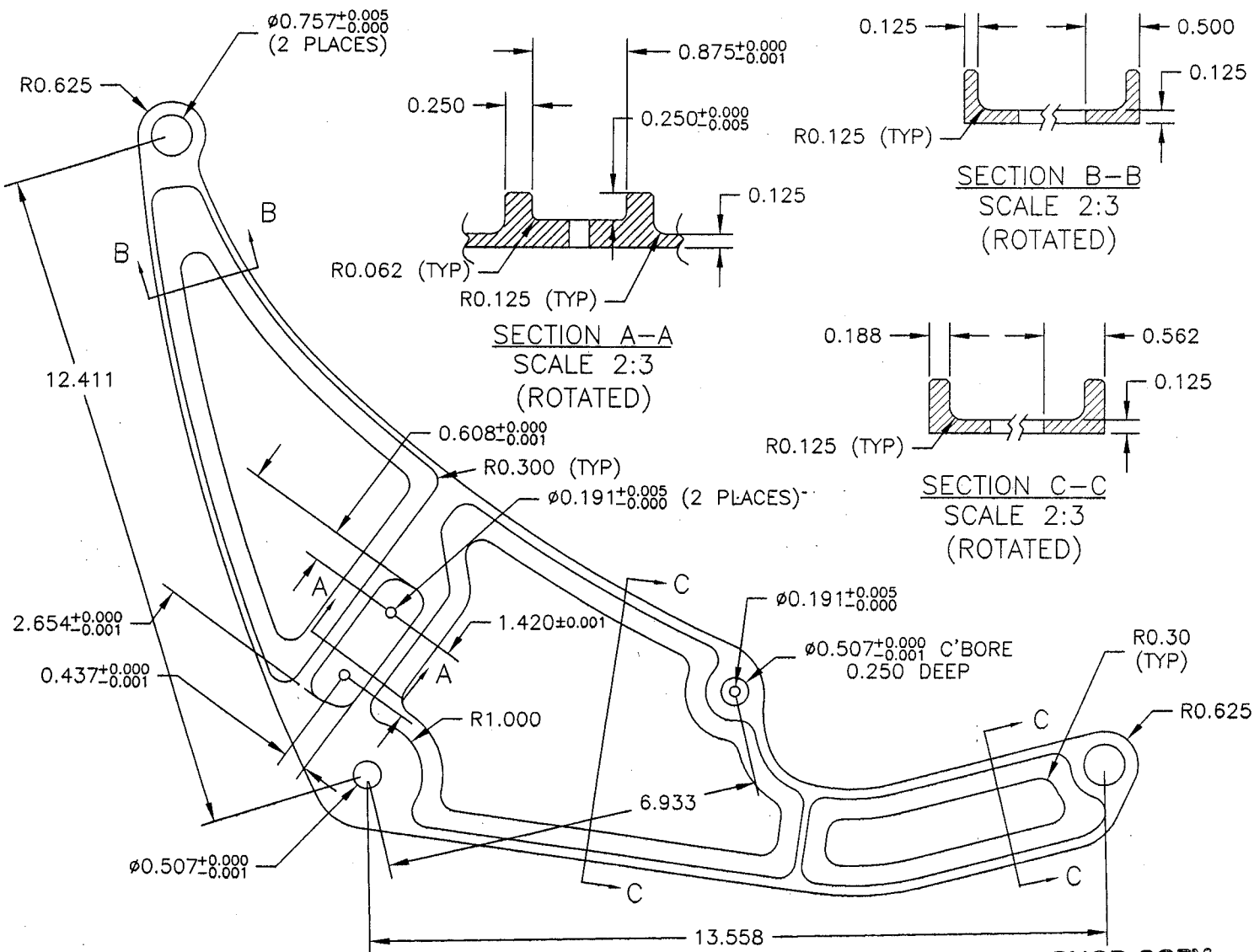
QA: N/C Closed: _____ Date: _____



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING

D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER

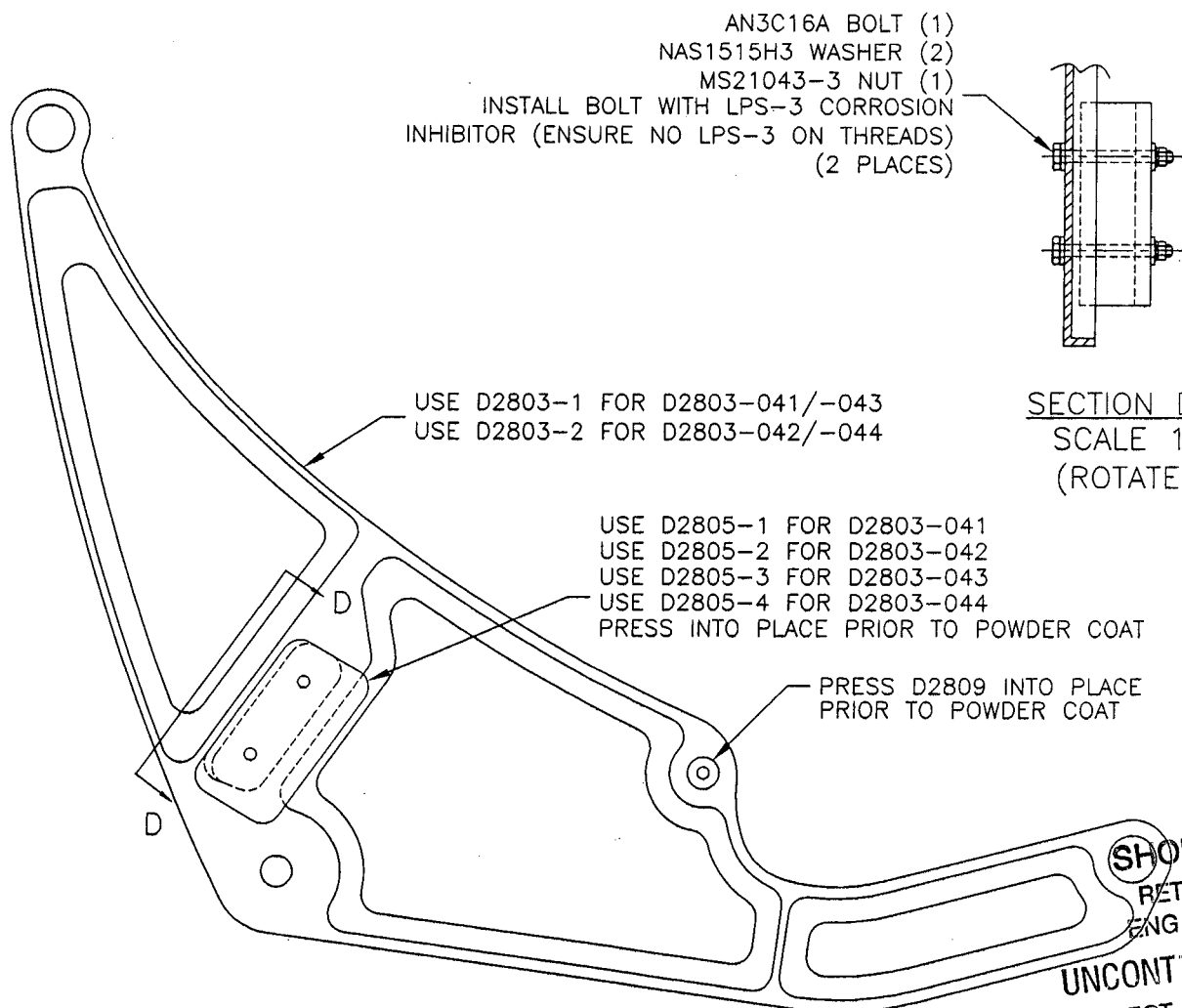
NO. 22514

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



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WORK ORDER

RELEASED
05-03-11 NO. 22514

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 22, 2005
03:39 pm

Work Order No : 0022514
Project Name : D2803-042
Project For : WK513
Work Order Type : Main
Main WO Number :
House Part Number : D2803-042
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 02-22-05
Est Finish Date : 03-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00